		,											_
Work Orde Thursday, July (Page 1	
Item ID: Revision ID:	D3255-1		A	Accept					Setup	Start			
Item Name:	Panel									Stop			
Start Date:	7/7/2011	Start Qty: 4.00			Cust Iten	ı ID:							
Required Date: Reference:	7/21/2011	Req'd Qty: 4.00			Custome	r:							
Approvals:	Process Pla	n: MF	Date: 11-07-07	Tooling:		Date:			Run	Start Stop			
	QC:		Date:	SPC (Y/N):		Date:				Stop			
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revi	ision Nbr											
D3255	Rev	В											
	:	FLOW WATER JET		0.00				1/21	u -8-	-10			
Waterjet		Memo		$Q^{0.00}$	0				<u> </u>				
FLOW CNC Waterj		l-Cut as pe Deburr if n	er Dwg D3255 DDwg Rev: necessary	OProg Rev:_	<u>13</u>						(4		
110		QC2- Inspect parts off	machine FAI/FAIB	0.00									
Q C		Memo		0.00				H3	1-8-	-10			
Quality Control	£												
, ·	ŕ												
120		QC8- Inspect parts - see	cond check	0.00									

1180lm &

Quality Control

Memo

0.00

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-	
Part No	<u> </u>	PAR #:	Fault Cated	orv:	NCR: Yes	No DQ	A:	Date:	
	Resolution:								
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			-
DATE	STEP	Description of NC	Corrective Action S Initial Action Description		on B		ation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Date	Secti	on C	Chief Eng	QC Inspector

Item ID:

D3255-1

Revision ID: Item Name:

Panel

Thursday, July 07, 2011 11:22:40 AM

Start Date:

7/7/2011

Start Oty: 4.00

Accept



Run

Setup Start





Required Date: 7/21/2011

Req'd Oty: 4.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Date: Tooling:

SPC (Y/N):

Date:

Tool ID

Date:

Tool # Plan

Reject

Oty

Start



Number Stamp

Insp.

Stop

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Memo

Form as per Dwg D3255

Set Up/ **Run Hours**

0.00 0.00 SB (168/23

Code

Reject

140

Quality Control

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location: WA

Memo

0.00

0.00 D W/08/24

Accept

Qty

150

Packaging Packaging

Memo

0.00

0.00

SP 11-68-24 5

W/O:			٧	VORK ORDER CHAN	GES					_
DATE	STEP	PRO	CEDURE CH	IANGE	В	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						_				
Part No	·	PAR #:	Fault Ca	tegory:	NCR: Y	es N	o DQ	A:	_ Date: _	
	R	esolution:	Disposit	tion:	QA: N/C Closed:				Date:	
NCR:		V	WORK OR	DER NON-CONFORM	MANCE (N	ICR)				
DATE	STEP	Description of NC			ection B		Verific	ation	Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Secti	on C	Chief Eng	QC Inspector
									,	

Work Order ID 71636

Thursday, July 07, 2011 11:22:40 AM



Page 3

Item ID:

D3255-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Panel

7/7/2011

Start Qty: 4.00 **Req'd Qty:** 4.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Required Date: 7/21/2011

Process Plan:

QC: ___

Date:_____

Date: _____

Tooling:

SPC (Y/N):

Date:

Start Run

Stop



Sequence ID/

Operation Work Center ID Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

Tool ID

Date:

Tool # Plan Code

Accept Reject Qty Qty

Reject

Insp. Number Stamp

160

Memo

0.00

0.00

Quality Control

W/O:		The Control of the Co	WO	RK ORDER CHANG	ES		•		
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			=-						
Part No	•	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	A:	Date:	
		solution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Secti		Verification Approva		Approval	Approval
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector
									·

Picklist Print

Thursday, July 07, 2011 11:22:37 AM

Work Order ID: 71636

Parent Item: D3255-1

Parent Item Name: Panel

Start Date: 7/7/2011

Required Date: 7/21/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA	18111 88811 184 1881	Purchased	No			100	sf	43.3600	1.484	6.248421			
304/316 032 Sheet										1B11-	8-10		

304/316 .032 Sheet

Location	Loc Qty	Loc Code		
020	5.8			1
109057	5.8		-	12
MAT020	37.56			()
117379	37.56		11 8400	
118400				

	•								
W/O:			WO	RK ORDER CHANG	GES			•	
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-									
								·	
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	_ Date: _	
		esolution:	Disposition	:	QA: N/C C	losed:	-	Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	?)			
DATE	STEP	Description of NC		ction B	Verific	cation	Approval	Approval	
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	& Sect	ion C	Chief Eng	QC Inspector
		,							

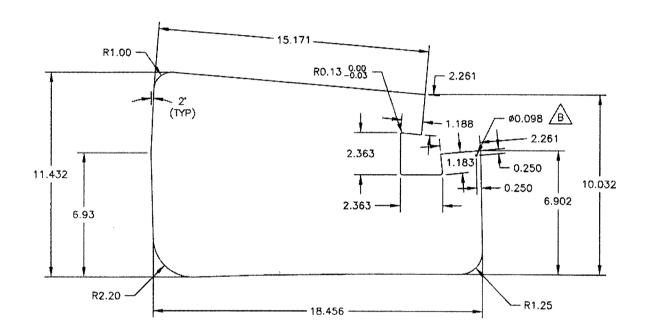
DART AEROSPACE LTD	Work Order:	71636
Description: Access Panel Assembly	Part Number:	D3255-1
Inspection Dwg: D3255 Rev: B		Page 1 of 1

	FIRST ARTICLE INSPECTION CHECKLIST									
	X	First Artic	cle	Proto	type					
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method Inspect		mments			
Ø0.098	+0.004/-0.001	,101	لي		V BO	2	· · · · · · · · · · · · · · · · · · ·			
15.171	+/-0.010	15/171	4		T BO					
10.032	+/-0.010	650.01	2		7	•				
6.902	+/-0.010	6.897	K -		7		·			
18.456	+/-0.010	18.456	D		7					
11.432	+/-0.010	11.435	O		7					
			,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,							
							 -			
						-				
			<u></u>							
Measured by:		Audited by:	2		Prototy	pe Approval:	N/A			
	8-10	Date:	Mosff			Date:	N/A			
	hange					Revised by	Approved			
	lew Issue					KJ/JLM	Approved			



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAI			*******
CHECKED	APPROVEO	DRAWING NO.		REV.	В
4	1 #	D3255	SHEET	3 OF	4
DATE ·		TITLE	inh-14444400000000000000000000000000000000	SCA	LE
04.12.06		ACCESS PANEL ASSEMBLY		1	:5







D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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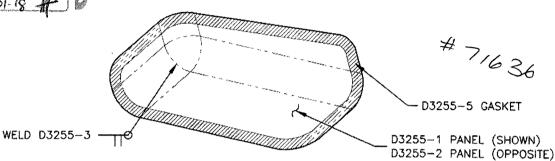
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W/O:			WC	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	·								
Part No	art No: PAR #: _		Fault Cate	gory:	NCR: Yes	No DQ)QA: Date:		
	Resolution:		Dispositio	n:	QA: N/C Clo	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC			n B	Verific	cation	Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	ion °C	Chief Eng	QC inspector
	}								
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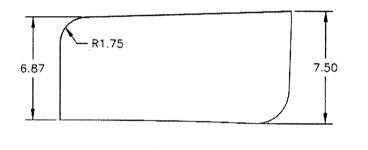


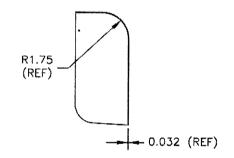
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CHEC	KED , A	APPROVED	DRAWING NO. REV.	В
	4"	- H-	D3255 SHEET 1 OF	4
DATE			TITLE SCAL	E.
04.1	12.06		ACCESS PANEL ASSEMBLY 1:	6
Α		04.01.27	NEW ISSUE	
В		04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

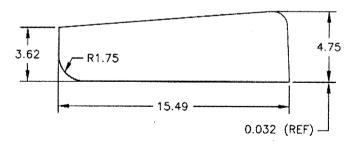




D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)







D3255-1 BEND DETAIL D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE
- WITH MANUFACTURE'S INSTRUCTIONS
 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	• •	PAR #:	Fault Cate	egory:	NCR: Yes No DQA: Date:				
	R	esolution:	Disposition	on:	QA: N/C Clo	A: N/C Closed:			
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NCR))			
DATE	STEP	Description of NC Section A	Corrective Action Section			Verification		Approval	Approval
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
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